Memo

0.00

Quality Control

120

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

B11-3-10

Dart	Aero	space	Ltd.
Duit	70 U	SDUCL	

								<b>6</b>
W/O:			WO	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	Part No: PAR		Fault Categ	ory:	_ NCR: Yes	No <b>DQA</b> : _	Date: _	·
	R	esolution:	Disposition	_ QA: N/C Cld	· · · · · · · · · · · · · · · · · · ·			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)		
DATE	STEP	Description of NC	Corrective Action				on Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section (	C Chief Eng	QC Inspector
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#### Work Order ID 66861

Tuesday, March 01, 2011 8:05:59 AM



Page 2

Item ID:

D3211-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Required Date: 3/7/2011

Bracket

3/1/2011

**Start Oty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID:** Customer:

Reference:

Start Date:

Αt	pro	va	ls:

Process Plan:

Date:

Tooling:

Date:

Tool ID

Start Run

Reject

Oty



OC:

Date:

**SPC (Y/N):** 

Date:

Tool # Plan

Code

Stop



Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

130



Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr

Set Up/ **Run Hours** 

0.00

0.00

NA

140



Brake NC

Brake NC

NC BRAKE

Memo

Memo

Bend D3211-1 Stack as per Dwg D3211

0.00

So 11/03/14

Accept

Qty

150



Quality Control

QC5- Inspect part completeness to step on W/O

d 11/03/14

Dart Aerosp	oace	Ltd
W/O-		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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				-					

Part No: <u>3211-1</u>	PAR #:	Fault Category			DQA:	Date: 11:09/6
Resolution:	Scupp	Disposition:	Scurp.	QA: N/C Closed	1: (V/	Date: 11/03/12

NCR: 6	821	WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
11/03/14	140	Description of NC Section A  I part first saide bend was out of tolerand  R.C process	11.05.4	Sonop + destoy No replace Ory 11	SVS 11/03/14	2	1503.4 05.1047.	nlos he
		R.C process	B)(04-	Ory as		1103/104	GHORT.	nlos hy
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#### Work Order ID 66861

Tuesday, March 01, 2011 8:05:59 AM



Page 3

Item ID:

D3211-1

Accept



Setup Start



**Revision ID:** 

**Start Date:** 

Item Name:

Bracket

3/1/2011

**Start Qty: 12.00** Req'd Qty: 12.00

**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

Run

Start

Stop



Required Date: 3/7/2011

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Sequence ID/ Work Center ID

160

HandFinish

Operation Description

Chemical Conversion Coat per QSI005 4.1

**Run Hours** 

0.00

Tool # Plan Code Accept Qty

Reject **Qty** 

Reject Number Stamp

Insp.

Hand Finishing

Memo

0.00

170

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M 112586

0.00

0.00

OVEN TEMPERATURE:

180

Memo

QC3- Inspect Part Finish

0.00

0.00

12 BL 11-3-15

12 b Il 11/03/15

Quality Control

Dart	Aerospace	Ltd

Dail AC	Uspace	Liu							\$
W/O:			WO	RK ORDER CHANG	SES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:		Disposition: QA			A: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)			
		Description of NC		Corrective Action Sec	tion B	Ve	erification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng			Section C	Chief Eng	QC Inspector
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#### Work Order ID 66861

Tuesday, March 01, 2011 8:05:59 AM



Page 4

Item ID:

D3211-1

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Bracket

**Start Date:** 

Required Date: 3/7/2011

3/1/2011

**Start Qty: 12.00** 

Req'd Qty: 12.00



Cust Item ID:

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: Date: \_\_\_\_\_

**Tooling:** 

SPC (Y/N):

**Run Hours** 

Date: Date:

Start Run

Stop

Sequence ID/ **Work Center ID** 

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

Set Up/

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Reject Qty

Insp. Number Stamp

Memo

0.00

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/16 Ty MF 11-03-15

Dart	Aerospace	Ltd
W/O:		

<b>D</b> uit 710.	oopaoc	, m.c.								, -
W/O:				WORK ORDER CHANGES						
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#### **Picklist Print**

Tuesday, March 01, 2011 8:06:04 AM

Work Order ID: 66861

Parent Item:

D3211-1

Parent Item Name:

Bracket



**Start Date: 3/1/2011** 

Required Date: 3/7/2011

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IPP Rev:A IPP Rev:B

New Issue

05-11-17 JLM Now on Waterjet 06-10-24 JLM

Component Item ID/	
Item Name	

Replacement Mfg/ Item ID

Purch

Primary Bin Item Location

Last Location

Route Seq ID Unit of Measure Hand

sf

Qty on

Loc Code

Qty per Kit Total

Qty Issued Date Issued

Status

Page 1

M2024T3S.063

Purchased

No

100

149.1270 1.405 Qty 17.74737

KB11-3-10

2024-T3 .063 sheet

Location	Loc Qty
MAT	144
117018	144
MAT22	5.127
113867	0.7
114351	4.427

117018

Dart Aerospace	Ltd
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W/O:			WC	ORK ORDER CHANG	ES					•
DATE	STEP	PRO	OCEDURE CHA	CEDURE CHANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCF	R: Yes	No <b>DQ</b>	A:	_ Date: _	
		esolution:								
NCR:		1	WORK ORD	ER NON-CONFORMA	ANCE	(NCR	)			
DATE	OTED	Description of NC	Corrective Action Section			Verification			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order: 💪	6861
Description: Bracket	Part Number:	D3211-1
Inspection Dwg: D3211 Rev: A1	F	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.25	+/-0.030	, <i>d</i> E	يح ا		RG.	
1.91	+/-0.030	1,931	₩		V 1802	
Ø0.128	+0.005/-0.000	.(DG)	155		٧	
Ø0.141	+0.005/-0.000	(142	*		V	
17.71	+/-0.030	ורגו	<b>*</b>		T 1801	
1.91	+/-0.030	1.933	٧		V	
1.56	+/-0.030	1.560	3-		V	
11.32	+/-0.030	11,32	يا		7	
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			1 1			
Measured by:	B	Audited by:	MIN		Prototype Approval:	N/A
Date:	11-3-10	Date:	11:03:10	)	Date:	N/A

Rev	Date	Change		Revised,b,y	Approved
Α	03.12.15	New Issue	P/O D350-567-015/-025/-031	KJ/RF	14

## **Dart Aerospace Ltd**

W/O:			WC	ORK ORDER CHANC	GES					
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Part No	•	PAR #:	Fault Cate	gory:	NCF	R: Yes	No <b>DQ</b>	A:	Date:	
		esolution:								
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR	)			
DATE	STEP	Description of NC			ction B	0' 0	Verifi	cation	Approval	Approval
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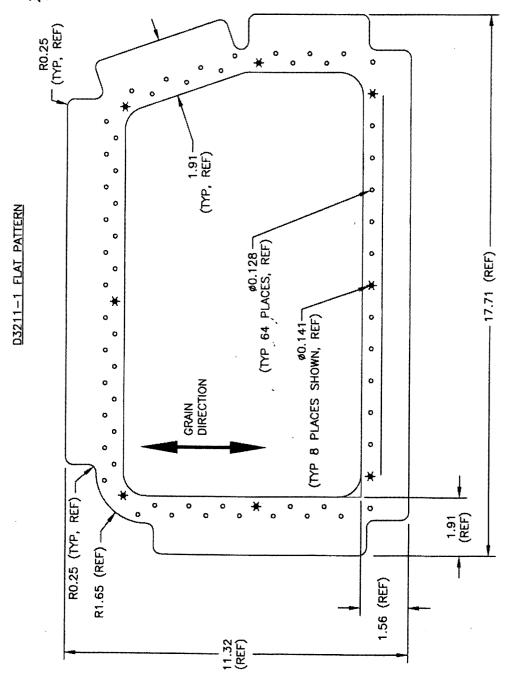




DESIGN (A)	DRAWN BY		ROSPACE LTD RY, ONTARIO, CANADA		
CHECKED //	APPROVED	DRAWING NO.		REV.	Α
#	- All	D3211	SHEET	2 OF	2
DATE	kuuutataatti	ME		SC/	UE.
03.09.03		BRACKET			1:3

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# DEO ATTACHED



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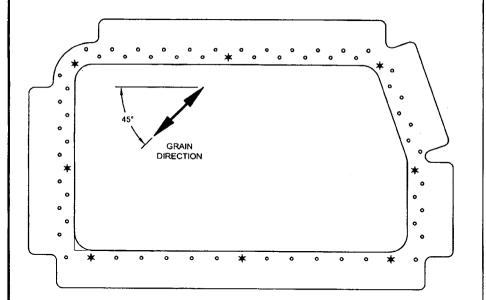
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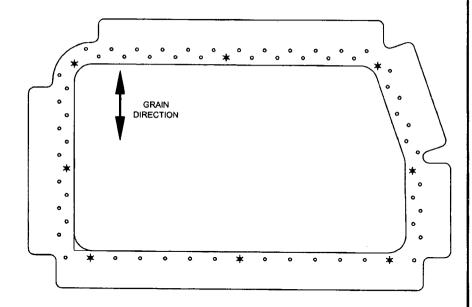
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DATE	08.09	.12	DATE	08.04 12	DATE 08.05.10	DATE CE CE 17	DATE OF 08 12	

SHEET 2 MODIFY GRAIN DIRECTION AS SHOWN BELOW TO FACILITATE BENDING (SEE CAR 08-001).

IS:



WAS:



ALL OTHER INFORMATION REMAINS UNCHANGED

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DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Description of NC		Corrective Action Section B	Verification	Approval	Approva	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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